

Date: Friday, 01/08/2008 1:05:38 PM  
 User: Jean-Luc Menard

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : BUSHING
Job Number : 40930	
Estimate Number : 11148	
P.O. Number :	Part Number : D32093
This Issue : 01/08/2008 S.O. No. :	Drawing Number : D3209 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : MACHINED PARTS	Drawing Revision : A
Previous Run : 35633	Material :
Written By : <u>JS 08-08-01</u>	Due Date : 08/08/2008 Qty: 20 Um: Each
Checked & Approved By : <u>JS 08-08-01</u>	
Comment : Est A 04.04.14 New issue KJ/RF	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M303R0500	303 Round Bar 0.500"
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Comment: Qty.: 0.0350 f(s)/Unit Total: 0.6993 f(s)

~~Delrin Round Bar .50" black~~

Material: AISI 303 SS Ø0.50"

(M303R0.500)

Identify for D3209-3

Batch:

M108626  
M103353

mmf 08/08/02



2.0	HARDINGE	HARDINGE CNC LATHE SMALL
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Comment: HARDINGE CNC LATHE SMALL

Turn D3209-3 bushing as per Folio FA354 and Dwg D3209

mmf 08/08/02



3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

mmf 08/08/02

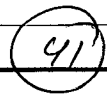


4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

mmf 08/08/03



5.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

5777

JS 08/08/05



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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BUSHING

Job Number: 40930

Part Number: D32093

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



(44)

Comment: FINAL INSPECTION/W/O RELEASE

Done 07

MF 08-08-06

Job Completion

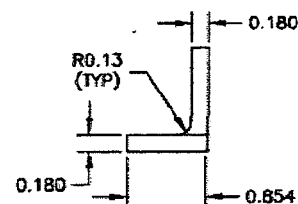
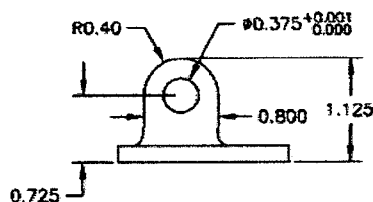
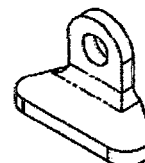
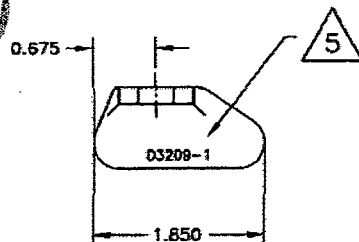






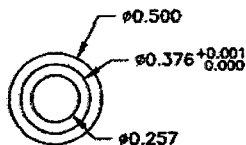
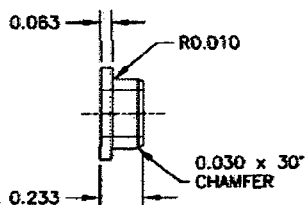
DESIGN H	DRAWN BY H	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. D3209	REV. A SHEET 1 OF 1
DATE 04.01.27		TITLE BRACKET	SCALE 1:2
A	04.01.27	NEW ISSUE	

RELEASED  
04.04.05 H



2

D3209-1 BRACKET



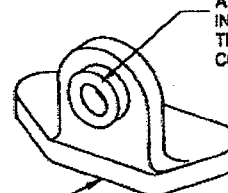
3

D3209-3 BUSHING  
SCALE 1:2

4

D3209-041 ASSEMBLY

D3209-3 BUSHING  
PRESS FIT, HEAD  
AT THIS FACE  
INSTALL AFTER  
THE CONVERSION  
COAT



D3209-1 BRACKET: D3209-3 BUSHING

- 1) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 2) MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-250/11 OR QQ-A-225/8)  
ALUMINUM BAR (M6061T6B)
- 3) MATERIAL: AISI 303 SS (M303R)
- 4) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT GREY SANDTEX (REF. 4.3.5.6) PER DART QSI 005 4.3
- 5) ENGRAVE DART P/N AS SHOWN
- 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 7) ALL DIMENSIONS ARE INCHES

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